

Date: Thursday, 2/14/2008 10:56:29 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	SADDLE LH (209)		
Job Number	37421					
Estimate Number	11598					
P.O. Number						
This Issue	2/14/2008	S.O. No.		Part Number	D29181	
Prsht Rev.	NC			Drawing Number	D2918 REV B	
First Issue	/ /	Type	MACHINED PARTS	Project Number	N/A	
Previous Run				Drawing Revision	B	
Written By				Material		
Checked & Approved By				Due Date	3/3/2008	Qty: 6 Um: Each
Comment	Est: A 04.07.16	New Issue	KJ/JLM			
	est B 07.08.07	ECN930	EC	verified by:JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6102011	6061-T6 8.25x6.5x2.5	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 6061-T6 8.25x6.5x2.5 Cut blanks: 2.500" x 8.250" x 6.50" grain along 6.50" Material: 6061-T6/T651 (QQ-A-250/11) (D6102-011) Identify as D2918-1 Batch: B37601			
			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	

Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number

Machine Step No 1 as per Folio FA441 and visually inspect as per Dwg D2918 & attached Dimension Sheet

Machine Step No 2 as per Folio FA441 and visually inspect as per Dwg D2918 & attached Dimension Sheet

Machine Step No 3 as per Folio FA441 and visually inspect as per Dwg D2918 & attached Dimension Sheet

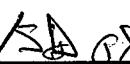
Deburr

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	

Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per Dwg D2918 & attached dimension sheet





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 29/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SADDLE LH (209)
Job Number: 37421		Part Number: D29181
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<i>2/14/08 08/03/13 (6)</i>
5.0	QC8	SECOND CHECK 
Comment: SECOND CHECK		<i>S.F. 08/03/13 (6)</i>
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		<i>M-1 08/03/14 (6X)</i>
7.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		<i>M-1 08/03/15 (6X)</i>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		<i>A.m. 08. 03. 15 (6)</i>
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		<i>8/3/11 30 (6)</i>
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		<i>12/03/19 (6)</i>
Job Completion 		<i>U 08.03.17</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order:

37421

Description: Saddle LH

Part Number:

D2918-1

Inspection Dwg: D2918 Rev. A1

IP 08.02.14

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2918 Rev. A1 and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.090	0.110		.093	.100	.100	.100		
B	0.175	0.205		.192	.190	.185	.192		
C	0.175	0.217		.178	.183	.179	.186		
D	R0.470	0.530		.500	.500	.500	.500		
E	0.740	0.760		.758	.755	.755	.755		
F	0.277	0.297		.280	.283	.279	.278		
G	3.170	3.230		3.197	3.195	3.195	3.193		
H	0.180	0.220		.182	.180	.180	.180		
I	1.599	1.614		1.614	1.612	1.612	1.612		
J	0.250	0.270		.267	.260	.260	.262		
K	4.436	4.446		4.436	4.437	4.437	4.437		
L	1.498	1.508		1.502	1.503	1.503	1.503		
M	1.278	1.288		1.283	1.283	1.283	1.283		
N	0.053	0.073		.053	.063	.063	.063		
O	1.103	1.113		1.107	1.107	1.107	1.107		
P	1.225	1.235		1.231	1.230	1.230	1.230		
Q	0.257	0.262		.260	.259	.260	.260		
R	1.900	2.010							
S	1.385	1.400		1.397	1.395	1.397	1.398		
T	0.760	0.765		.760	.760	.760	.760		
U	0.307	0.312		.310	.310	.310	.310		
V	0.615	0.635		.623	.625	.626	.627		
W	0.438	0.443		.441	.441	.441	.441		
X	0.490	0.510		.491	.495	.495	.495		
Y	1.745	1.755		1.751	1.750	1.750	1.750		
Z	3.495	3.505		3.500	3.500	3.500	3.500		
AA	7.990	8.010		7.996	8.002	8.002	8.002		
AB	2.000	2.020		2.000	2.000	2.000	2.000		
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: *GRD/SD*
Date: 08/03/13Audited by: *SP*
Date: 08/03/13

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM <i>SP</i>	<i>SP</i>

DART AEROSPACE LTD

Work Order: 37421

Description: Saddle LH

Part Number: D2918-1

Inspection Dwg: D2918 Rev. A1 *B* *08.02.14*

Page 1 of 1

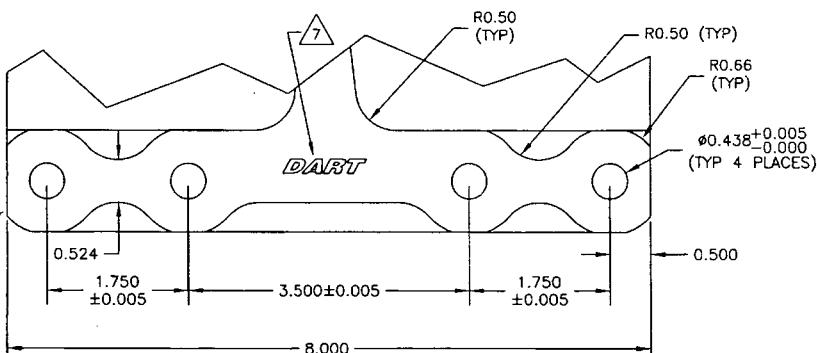
Inspect dimensions highlighted on inspection sheet drawing D2918 Rev. A1 and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.090	0.110		-100	-100				
B	0.175	0.205		-289	-290				
C	0.175	0.217		-183	-181				
D	R0.470	0.530		-500	-500				
E	0.740	0.760		-755	-750				
F	0.277	0.297		-275	-275				
G	3.170	3.230		3.193	3.193				
H	0.180	0.220		-180	-180				
I	1.599	1.614		1.612	1.612				
J	0.250	0.270		-261	-260				
K	4.436	4.446		4.440	4.440				
L	1.498	1.508		1.504	1.504				
M	1.278	1.288		1.283	1.283				
N	0.053	0.073		-063	-063				
O	1.103	1.113		1.108	1.108				
P	1.225	1.235		1.230	1.230				
Q	0.257	0.262		-261	-261				
R	1.990	2.010							
S	1.385	1.400		1.397	1.397				
T	0.760	0.765		-760	-760				
U	0.307	0.312		-310	-310				
V	0.615	0.635		-624	-625				
W	0.438	0.443		-440	-440				
X	0.490	0.510		-498	-498				
Y	1.745	1.755		1.750	1.750				
Z	3.495	3.505		3.500	3.500				
AA	7.990	8.010		8.002	8.002				
AB	2.000	2.020		2.001	2.001				
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>SD</i>
Date:	<i>08/03/13</i>

Audited by:	<i>8.5</i>
Date:	<i>08/03/13</i>

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM <i>SD</i>	<i>SD</i>



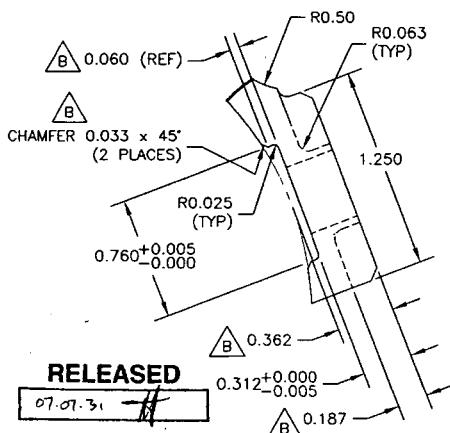
VIEW B-B

D2918-1 LH SADDLE (SHOWN)

D2918-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/11
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125



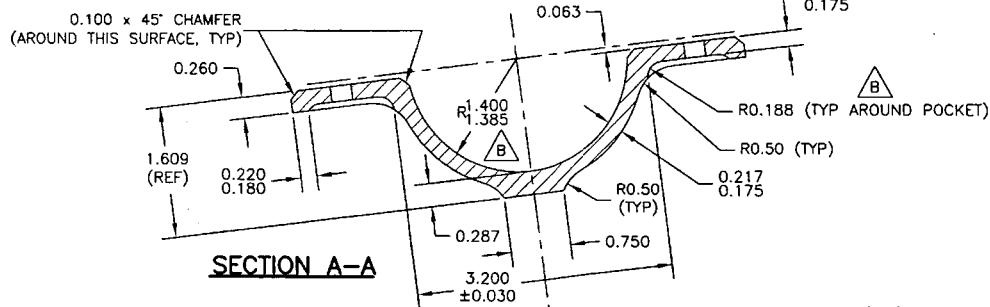
DETAIL C

SCALE 4:3

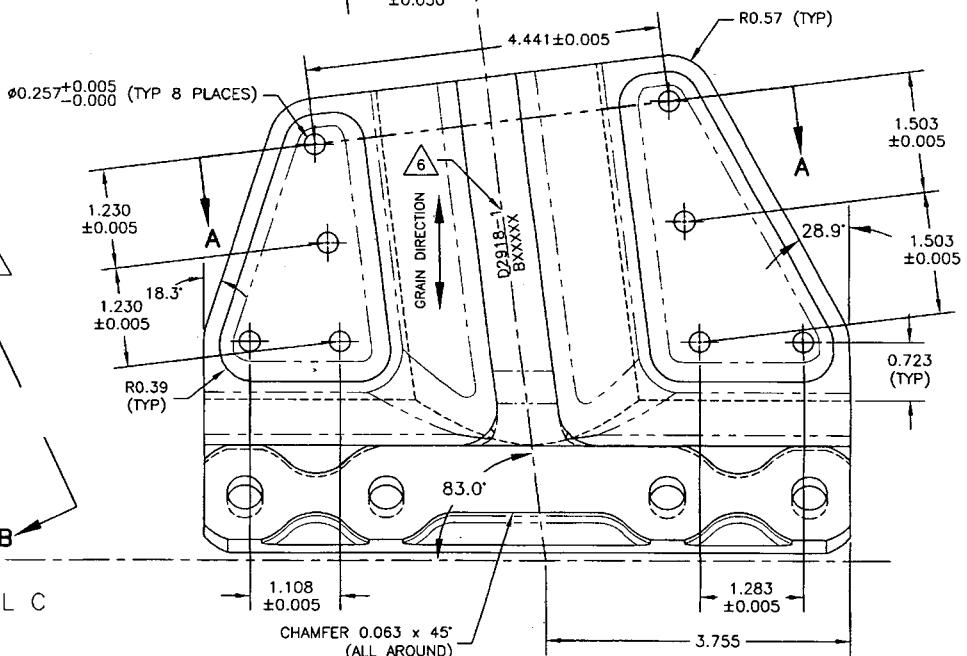
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NO. *W0002*

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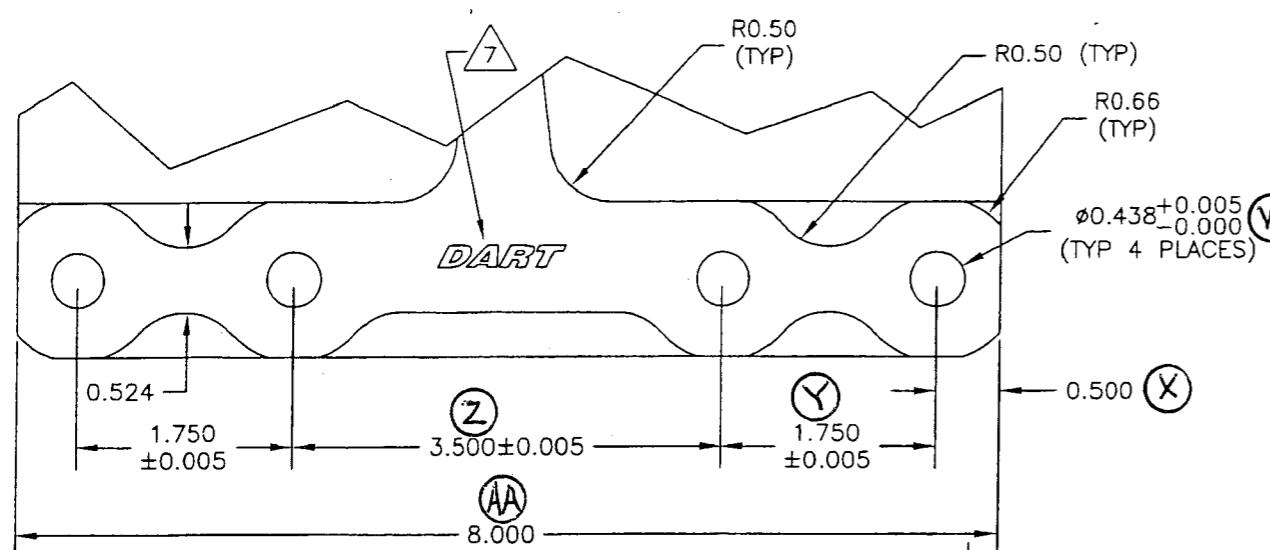
SECTION A-A



B	07.02.19	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES
A	04.05.31	NEW ISSUE
DESIGN	<i>97</i>	DRAWN BY <i>CB</i>
CHECKED	<i>PH</i>	APPROVED <i>MM</i>
DATE	07.02.19	DRAWING NO. D2918 REV. B SHEET 1 OF 1 TITLE SADDLE SCALE 2:3

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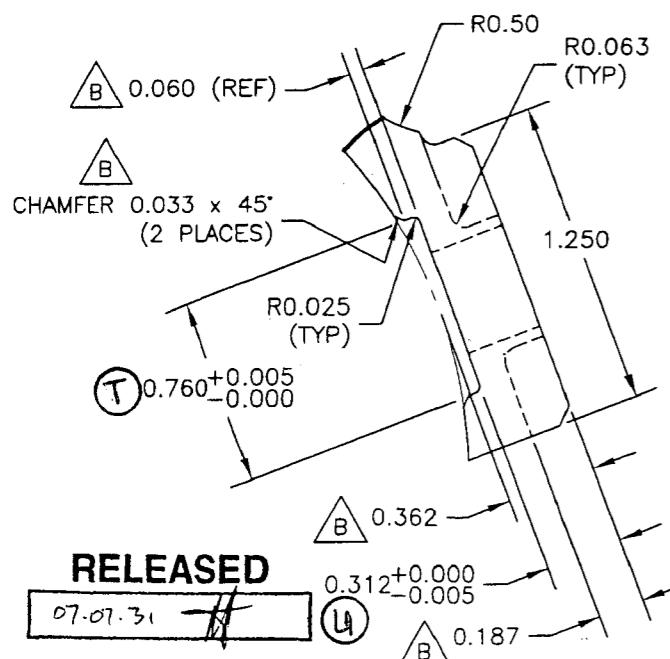


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DETAIL C **B**

SCALE 4:3

RELEASED

07.07.31

H

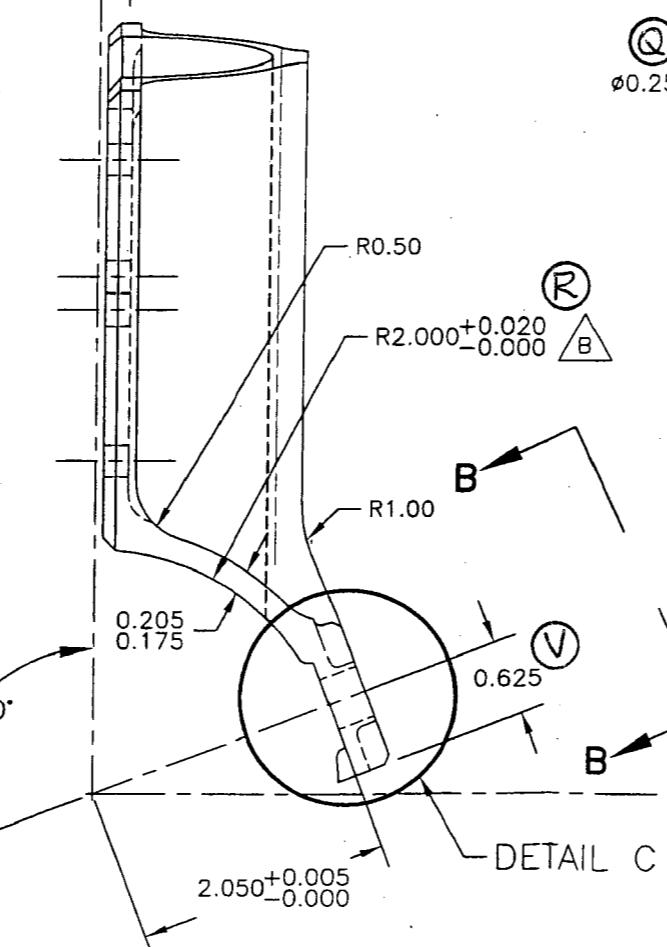
L4

B

0.312+0.000/-0.005

B

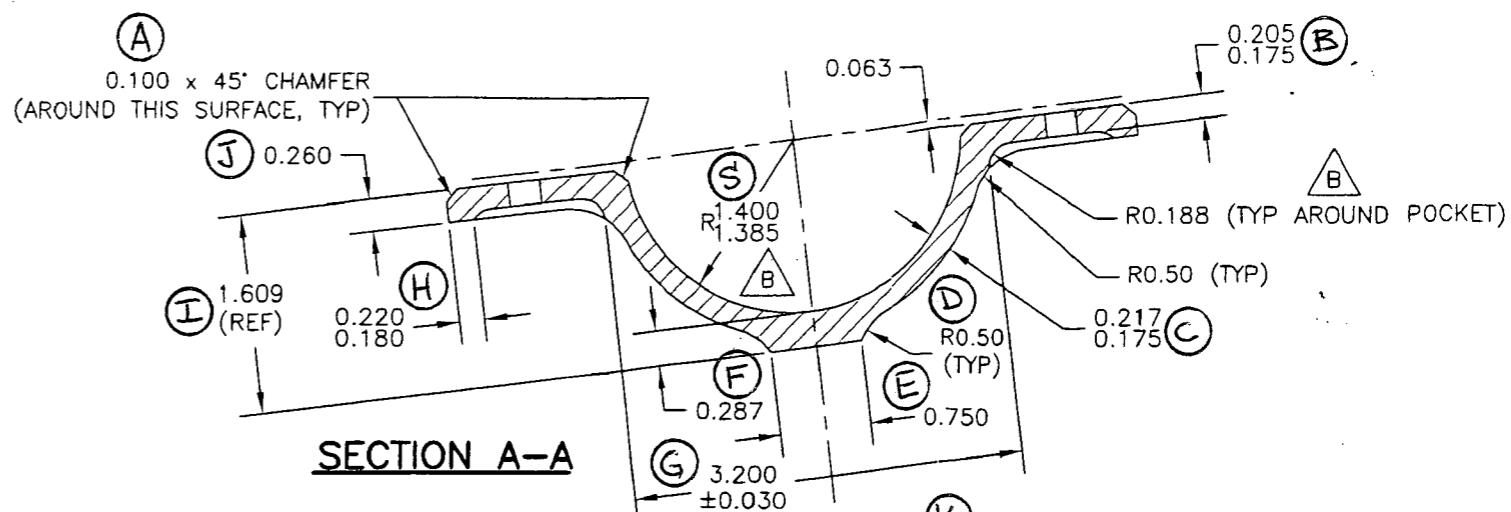
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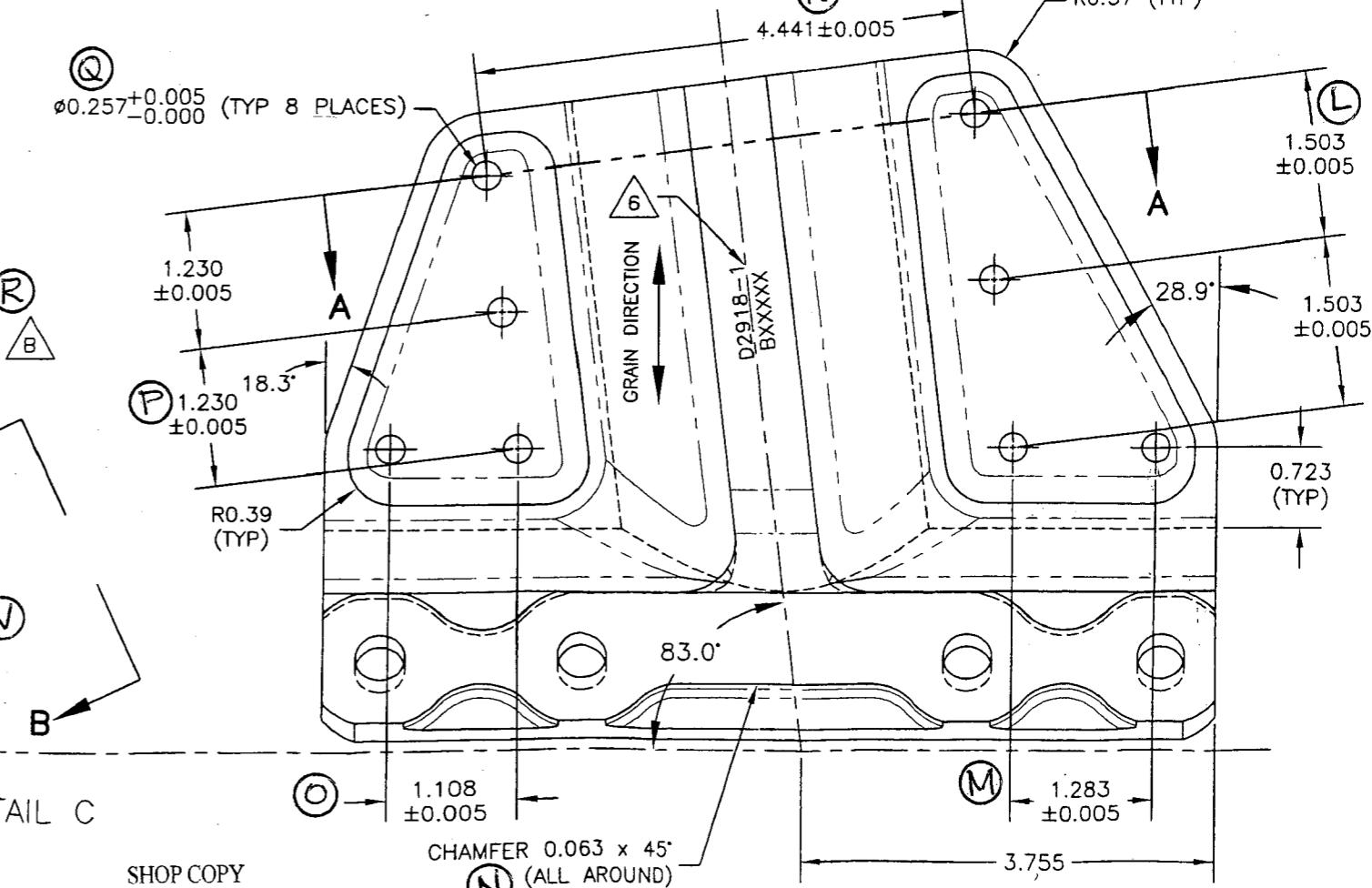
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SECTION A-A



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B	07.02.19	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES
A	04.05.31	NEW ISSUE
DESIGN	9P	DRAWN BY CB
CHECKED	PH	APPROVED H
DATE	07.02.19	DRAWING NO. D2918
SCALE	2:3	TITLE SADDLE

REV. B

SHEET 1 OF 1

SCALE

2:3